

Date: Wednesday, 3/12/2008 1:50:57 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ASSEMBLY
Job Number	: 37873		
Estimate Number	: 11527		
P.O. Number	:	Part Number	: D3021041
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D3021/D3017
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A/A
Previous Run	: 37872	Material	:
Written By	:	Due Date	: 4/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>08 13 12</u>		
Comment	: Est. 01.10.23 New Issue SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 2.1875 f(s)/Unit Total : 2.1875 f(s)

4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall batch: H103012PD 08-05-29

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D3021-041T1

3--Deburr

PD 08-05-29

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/06/10

4.0	M4130NS049	4130 Sheet .049 wall
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Comment: Qty.: 1.0500 sf(s)/Unit Total : 1.0500 sf(s)

4130 Sheet .049 wall

Cut:- AISI 4130N sheet, 18 gauge (0.050 thick)

batch: H11612

Identify For D3017-11 Cap

PD 08-05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: TUBE ASSEMBLY

Job Number: 37873

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut end caps as per Dwg D3017

2-Weld as per Dwg D3021

A/R Steel Rod Batch: M100015

PD 08-06-10

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M10 3642

m-1 08-06-10

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/06/10 ①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/06/10 ①

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12 JH

Job Completion



MF 08-06-12

30 min
10/06/2008
S.002 13.24
#1 318 F
#2 1337873 F
#3 F
#4 03021041 F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

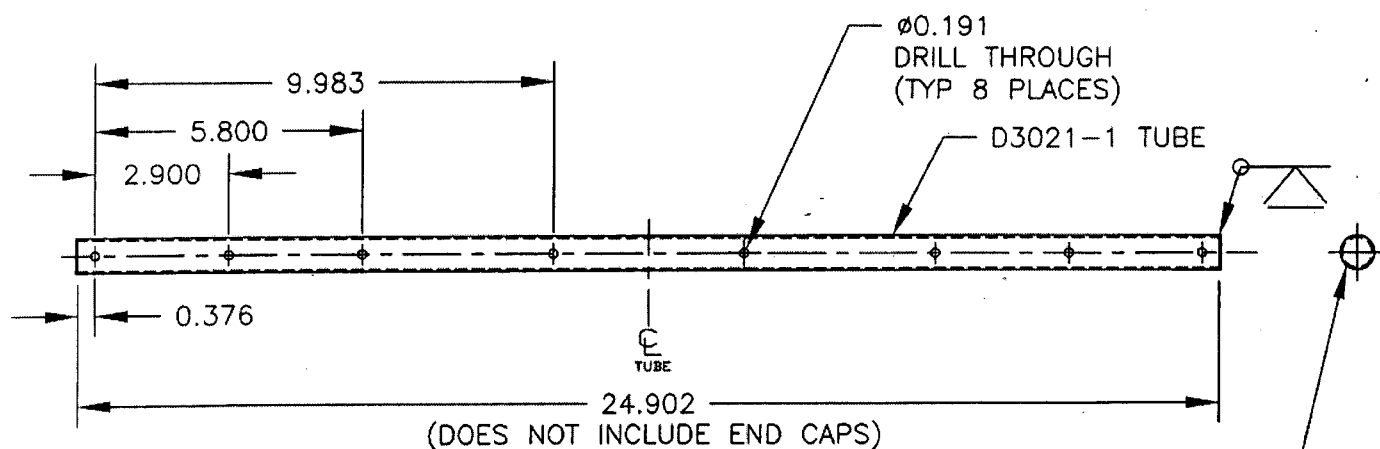
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

D3017-11 END CAP
(2 PLACES)

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37873

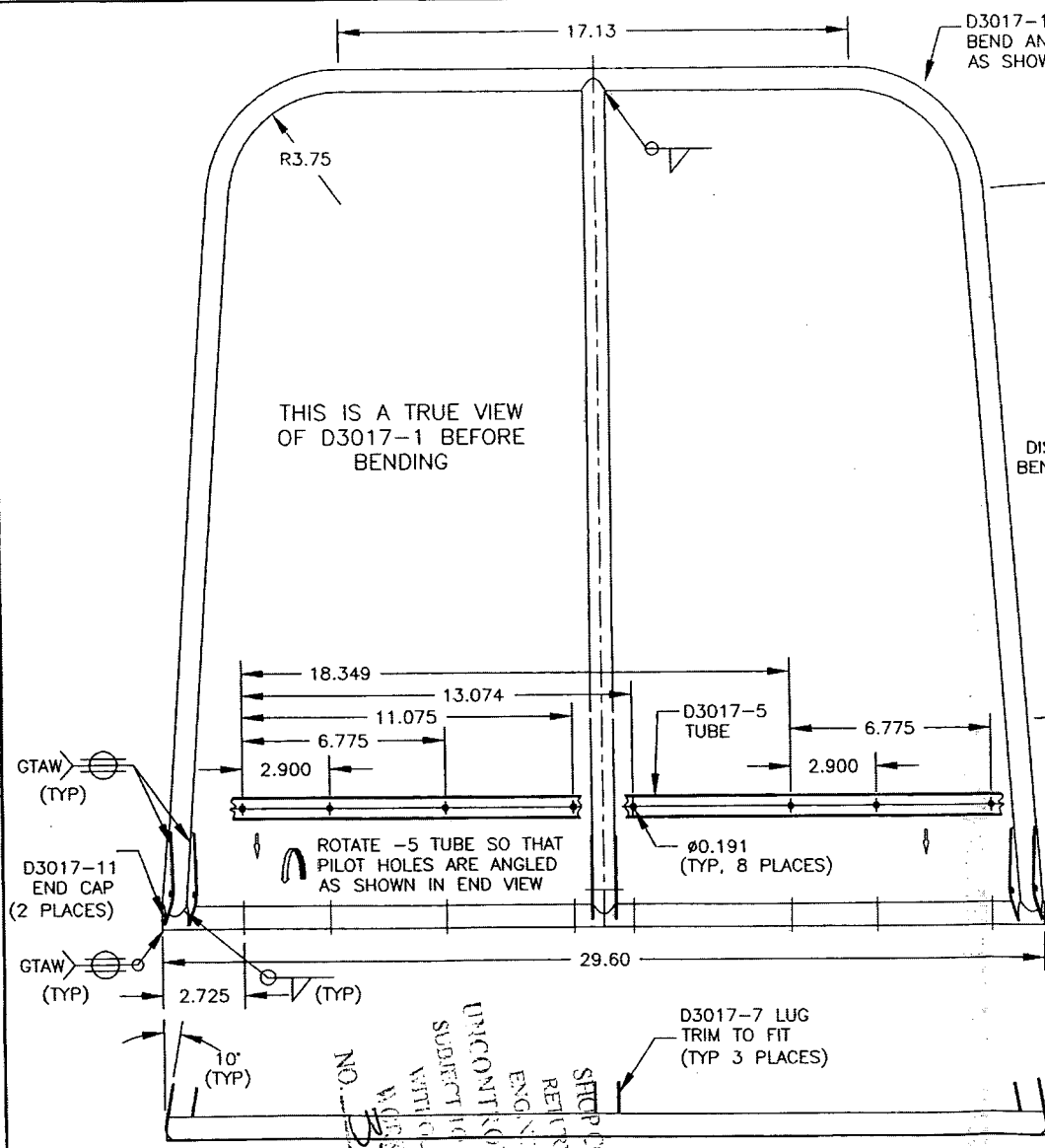
NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01-05-309

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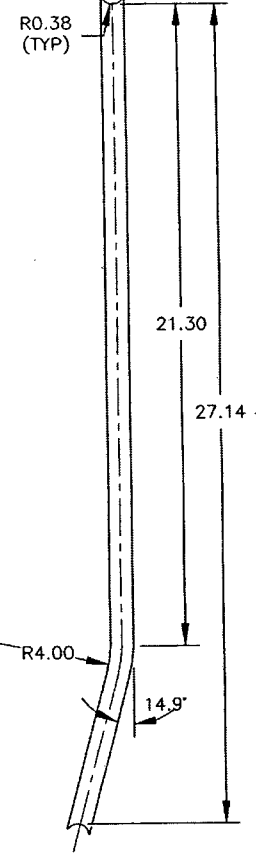
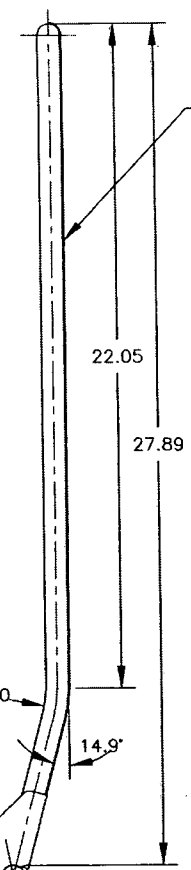


D3017-1 TUBE,
BEND AND CUT
AS SHOWN

17.92
DIST BETWEEN
BEND TANGENTS

DRILL Ø0.128 HOLES TO LINE UP
WITH D3023-1 BACK PANEL

26.2°
ANGLE
TO HOLE
CENTERLINE



D3017-3 TUBE

RELEASED
01-06-07

NO. 27873
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 RETURN TO
 SHIP COPY
 ENGINEERING

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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		DATE 01.05.18	DRAWING NO. D3017	TITLE BACK FRAME ASSEMBLY	